



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18520-5
Job Sheet 178064



Part No: RBT18520-5

Job Qty: 2 ea

Part Name: Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/25/18

Job Tracking No:

Due Date: 8/7/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18520-5 REV:11 IPP REV A 18.02.06 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		8/7/18	0.00	0.00	Start Up Large Fab-7		EL
100	Large Fab	2 pcs		8/7/18	0.08	0.33	Large Fab 8		EL
110	QC	2 pcs		8/7/18	0.00	0.00	QC9		MS
130	Outsource	2 pcs		8/7/18			GRO002-VC	10	
140	Packaging	2 pcs		8/7/18	0.00	0.00	Packaging2		DOB 08/31/18
150	QC	2 pcs		8/7/18	0.00	0.00	QC6		EP
160	Packaging	2 pcs		8/7/18	0.00	0.00	Packaging3-2		MLC
170	QC21-SA	2 Ea		8/7/18	0.00	0.00	QC21		

Part Op 100 - WELDING

Descriptions: 130 - Issue P/O to Groupe Aitech; PO 040901 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required
140 - Receive
160 - IDENTIFY AND STOCK

COLD B/O IS ACCEPTABLE
MEL AUG 30/18

DAS
13
9-89

AUG 30 2018

x2

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT18520-3	Top Bolt Tab	2 Ea (1 ea)	90-Start up Operation	5106812
RBT18520-5A	Top Bolt	2 Ea (1 ea)	90-Start up Operation	9057103

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBT18520-3	2	0	0
	RBT18520-5A	2	12	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ifications

ould not be found.

Container No: S107020



Part: RBT18520-5

Job No: 178064

Serial No/Batch: S107020

Revision: 11

Inspector:

Exp Date:

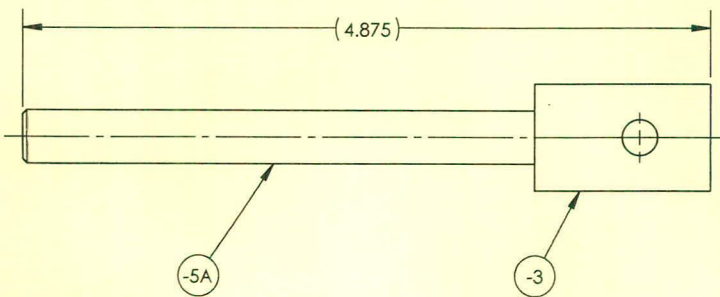
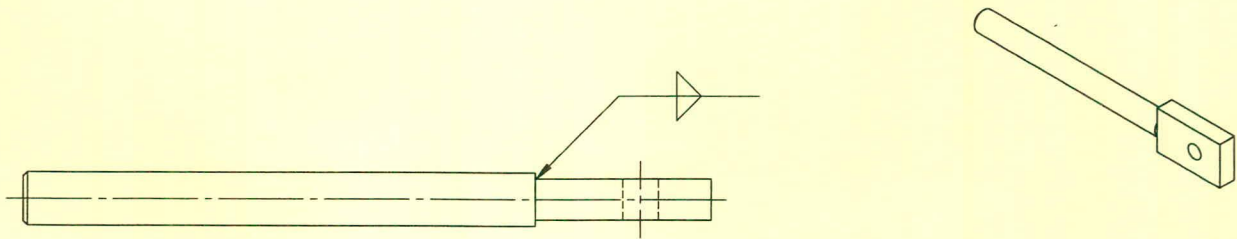
Instructions:

Date: 08/30/18

Plex 8/30/18 9:25 AM dart.logan.david

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(5)
TOP BOLT WELDMENT

DART AEROSPACE	
TITLE ROTOR DAMPER TEST DEVICE	
DWG NO. RBT18520-5	REV 11
MAT'L REAY	UNLESS OTHERWISE SPECIFIED
TREAT FINISH BLACK OXIDE	DIMENSIONS ARE IN INCHES XXX ± .010 FRACTIONS ± 1/8 XX ± .03 ANGLES 21° X ± .1 SURFACES = 125/
SPEC QMSI-6.2.2 REV D	1. BREAK ALL SHARP EDGES .016 x 46° OR .016R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 8/17/2000
SHEET 4 OF 17	

11-22-2000 NAK add Black oxide

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other		AGAINST DEPARTMENT/PROCESS				
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By _____
								Lead hand / Supervisor Approval Verification _____
								QC / QA Coordinator Approval _____
Root Cause ☐ Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due				FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes				
☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center				☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence				
OTHER : _____								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040901**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040901

PO Date: 8/30/18

Due Date: 8/31/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
AUG 31 2018

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178064	RBT18520-5	Weldment -Issue P/O to Metec; PO cold b/o is acceptable	Firmed	-	8/31/18	2 pcs	0 pcs	2 pcs	\$45.00/pcs	\$90.00
Grand Total:											\$90.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/30/18 1:54 PM dart.lavoie.chantal

62-40A 2-2



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Hawkesbury, ON
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Canada

Tel (613) 632-5200
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SUBCONTRACT SHIPPER

SUBCONTRACT SHIP TO

Ship To: Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill, ON K0B 1R0 Canada
Phone: 613 678 3957 **Fax:** 613 678 3956

SHIPPER

Shipper No: 577
Shipper Date: 8/30/18
Carrier: *
Ship Via:
Vehicle Reg:
Note:
Freight Terms:

Part Information

Part No: RBT18520-5 **Name:** Weldment
Cust Part No: **Product Family:** Tools
Reference No: **Piece Weight:** 0 lbs
Part Information Note: DWG RBT18520-5 REV:11 IPP REV A 18.02.06
NEW ISSUE RQ VERIFIED BY DP **Alloy Type:**
Drawing No: **Alloy - Temper:** -
Program: **Description:**
Program Customer: **Quantity:**
Addl Docs:
Commercial: Product Line: Tools
Primary OEM Application: MD Helicopters
Manufacturer: DART
Business Segment: Tools & GSE
Advertised on web?: No

OPERATION

Operation: Outsource - 130
Description: -Issue P/O to Groupe Altech; PO _____ -
Black oxide finish, MIL-C-13924C Class 1 -Certificate
of Conformity is required
Note:

DETAIL

Part	Operation	PO	Job	Container	Heat Code	Net Weight (lbs)	Gross Weight (lbs)	Quantity
RBT18520-5	Outsource -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required	PO040901	178064	S107020		0	0	2

Driver Signature _____

Customer Copy

Plex 8/30/18 2:03 PM dart.lavoie.chantal

David Logan

From: Robert Aboud
Sent: Thursday, August 30, 2018 9:37 AM
To: David Logan; Chrisoula Tsimiklis
Cc: Jean-Luc Menard; Mathieu Leclair
Subject: RE: Red Barn Order 7546 ship 8-31 --- to send to METEC , W/O 178064 (DEV Mike.Lee , Cold B/O is acceptable)

Categories: Orange, Yellow

Please bring the part(s) to me when they are ready

Rob Aboud

Director of Supply Chain

DART AEROSPACE

T 1-613-632-5200 Ext.244

M 1-514-979-6138

www.dartaerospace.com



From: David Logan
Sent: Thursday, August 30, 2018 9:33 AM
To: Chrisoula Tsimiklis <ctsimiklis@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>; Mathieu Leclair <mleclair@dartaero.com>; Robert Aboud <raboud@dartaero.com>
Subject: Red Barn Order 7546 ship 8-31 --- to send to METEC , W/O 178064 (DEV Mike.Lee , Cold B/O is acceptable)

Job Operations

Job No: 

Part No: RBT18520-5 Job Qty: **2 ea**

Material:

Part Management

Process Routing

Add New Part Operation

Set as Primary Routing

Op No	Operation	Op Qty	Start Date	Due Date	Center	Standard		
						Setup hrs	Run Hrs	
<u>90</u>	Start up Operation	2		8/7/18	Start Up Large Fab-7	0.00	0.00	<u>8/7/18</u>

Op No	Operation	Op Qty	Start Date	Due Date	Center	Standard		
						Setup hrs	Run Hrs	
<u>100</u>	Large Fab	2		8/7/18	Large Fab 8	0.08	0.33	<u>8/7/18</u>
<u>110</u>	QC	2		8/7/18	QC9	0.00	0.00	<u>8/7/18</u>
<u>130</u>	Outsource	2		8/7/18	Outsource12	0.00	0.00	<u>8/7/18</u>
<u>140</u>	Packaging	2		8/7/18	Packaging2	0.00	0.00	<u>8/7/18</u>
<u>150</u>	QC	2		8/7/18	QC6	0.00	0.00	<u>8/7/18</u>
<u>160</u>	Packaging	2		8/7/18	Packaging3-2	0.00	0.00	<u>8/7/18</u>
<u>170</u>	QC21-SA	2		8/7/18	QC21	0.00	0.00	<u>8/7/18</u>



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Canada

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Subcontract Receipt History

Supplier Shipper No: * Part No: * Job No: 178064
Unfinalized Only: No Supplier: * Receipt Date: 8/24/2018 - 8/31/2018
PO No: *

Supplier Shipper	Supplier	PO No	Receipt Date	Part No	Container No	Job	Qty	Net Weight	Special Comments
23009	MEM001-VC	PO040901	8/31/18	RBT18520-5	S107020	178064	2	0.00	
Shipper Total					1		2	0.00	
Grand Total					1		2	0.00	



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 23009
Date: Aug 30, 2018
Page: 1

Sold to: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO040901	Sold By: Walz, Christian D.
Shipped By: pick up	Ship Date: Aug 30, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
Cold black oxide finish on RBT18520-5 Weldment		Each	2	2	213
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					

Received by _____

Thank you for your order!

